Work Order ID 98630 *98630* Friday, March 15, 2013 3:36:38 PM Item ID: D3183-045 *N900040100* Accept Revision ID: Bearing Assembly Item Name: **Start Date:** *10* 3/15/2013 **Start Qty: 10.00** Cust Item ID: **Required Date: 3/18/2013** Reg'd Oty: 10.00 **Customer:** Reference: Date: 13-3-15 Run **Approvals:** Process Plan: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3183 Rev C1 130 0.00 Small Fab *130* Small Fab 0.00 Memo Small Fab Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183. 140 QC5- Inspect part completeness to step on W/O *140* (0) QC 0.00 Memo Quality Control Identify as per dwg & Stock Location 150 0.00 *150*

0.00

Memo

Packaging

Packaging

											DQA:	Date	:	
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE								
					**						QA Closed:	Date	:	
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS							
						Rework			Skid-tube	Crosstube]	Water Jet	Engineering	
Part I	۷o.					Scrap	4		Machining	Small Fab	-1	d. Eng. Coor.	Quality	
NCR I	۷o.					Use-as-is Work Order Update		E .	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root					Descri	ption of work order update		Initial	A	ction	Sign &		T	
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Des	cription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling]					1						
Operator														
Material														
Setup														
Other														
Process							1							
Supplier														
Training														
Unapproved														
						F	AUI	LT CATE	GORY					
Landi	ng (Gear				General		_			_			
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct [Weld	
		Crushed/	Crimped		Γ	Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination	Г	Mainte	nance		Part Moved	_		
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong		
Inspection Strip in Tube Cut Too Short					Misread			Power Loss/	Surge	Other				

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Item ID:

D3183-045

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Bearing Assembly

10 **Start Qty: 10.00**

Stop

Start Date: 3/15/2013

Required Date: 3/18/2013

Req'd Qty: 10.00

10

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Qty

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty

Reject

Insp. Number Stamp

160

160

QC

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

mx 3-180

Quality Control

NCR: Y	'es /	No				WORK ORDER NON-CONFORMANCE / UPDATE									
											Q	A Closed:	C	ate:	
Work Order: Part No. NCR No. Root Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other Process				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No.						Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descri	ption of work order update		Initial	Acti	ion		Sign &			
Cause	C	ate	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landii	Cer Cra Cru Cut	nding otre No cks shed/0 fs at Trea	ot Concer Crimped t n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4	on Incomplete ions Incomplete/U nance led	Inclear	P:	valized ver/Under art Incorrec art Lost/Mis art Moved ositioned W ower Loss/S	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Rin	nles in	Rend			Drill Holes		Offcot		_	_				

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Picklist Print

Friday, March 15, 2013 3:36:38 PM

Work Order ID:

98630

Parent Item:

D3183-045

Parent Item Name:

Bearing Assembly

Comments:

IPP A04.02.18New issueKJ/DS

		-
		'

Start Date: 3/15/2013

Required Date: 3/18/2013

Page 1

Start Qty: 10.00

Required Qty: 10.00

Com	iments:	IPP A04.02.18Ne	w issueKJ/DS											
	nponent Item ID/ Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D318			Manufactured	No				Each	22.0000		10	01	1	/
Cap D3183-5 Bearing		Manufactured	No	Location FG 89492 ST235 96380		Loc Oty 5 5 17 17	<u>Lo</u> Each	c Code		$= \frac{10}{10} \frac{3}{3} $] 	
					Location ST235B 748 778 815 896 973	31 06 17	Loc Otv 116 1 1 19 1 94	<u>Lo</u>	c Code			J-10)	ון בטן	, O

										DQA:	Date	e: '
NCR: Y	es / No				WORK ORDER NON-	CONFO	ORM	IANCE / UP	DATE	QA Closed:	Date	
					T						Date	e:
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	1	Skid-tube Crosstube			7	Water Jet	Engineering
Part N	lo.				Scrap	1		lachining	Small Fab	Pro	d. Eng. Coor.	Quality
			Use-as-is	TͰ	nermo	oforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	10		-		Work Order Update				Composite]	Supplier	
Root					ption of work order update	Initia	al	Ac	tion	Sign &		1
Cause	Date	Step	Qty		or Non-conformance	Chief I	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						ļ. ģ						
Operator												
Material												
Setup			1 1				- 1					
Other												
Process						1						
Supplier										İ		
Training		ļ				1						
Unapproved							L			<u> </u>	<u> </u>	
					F	AULT C	ATEG	ORY				····
Landi	ng Gear			 -	General					7	<u></u>	
	Bending			.	Bend	Gra				Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Concei	ntric to O	^{0/S}	BOM/Route	\vdash	dware		<u> </u>	Over/Under	 	Temperature/Cure
	Cracks			-	Broken/Damaged			n Incomplete	–	Part Incorre	<u> </u>	Weld
	Crushed/	Crimped		<u> </u>	Burrs			ons Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	\vdash		nance	<u> </u>	Part Moved		
	Heat Trea			<u> </u>	Countersink	—	slabele	ed	ļ	Positioned V	_	٦٠٠٠
	Inspectio		Tube	<u> </u>	Cut Too Short	\mapsto	sread		<u> </u>	Power Loss/	Surge	Other
	Ripples ir			<u> </u>	Drill Holes	Off						
· · · · · · · · · · · · · · · · · · ·	Torque V			<u> </u>	Drawing	-		alibration				
i	Turning S	Sequence		I	lFinish	I lOut	t of Se	equence				

Outside Dimensions

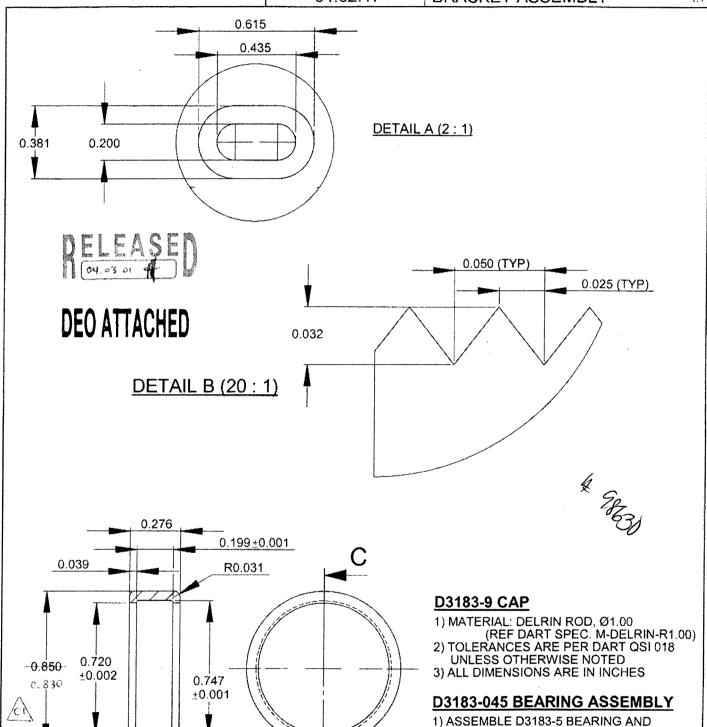
Wave/Twist in Tube

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECKED	APPROVED	DRAWING NO.	REV. C SHEET 4 OF 4					
DATE		TITLE	SCALE					
04	02.17	BRACKET ASSEMBLY	1.1					



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D3183-9 CAP

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R0.010

SECTION C-C SCALE 2:1

						•				DQA:	Date:	
NCR: Y	es / No				WORK ORDER	R NON-COI	NFORN	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	r:				DISPOSIT	ION			AGAINST DE	EPARTMENT	/PROCESS	·
Part N					ł	Sework Scrap Se-as-is Jpdate	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Desc	ription of work order or Non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other Process supplier Training Unapproved												
						FAUI	LT CATE	GORY				
Process Supplier Training Unapproved FAULT CATEGORY Landing Gear Bending Centre Not Concentric to O/S Cracks Broken/Damaged Grain Hardware Inspection Incomplete				Ovalized		Pressure/Forced						
	Cracks		ntric to (o/s	Broken/Damaged		Inspecti	on Incomplete		Over/Under Part Incorre	ct	Temperature/Cure Weld
-	Cuffs Heat Trea	at		-	Burrs Contamination Countersink	-	Mainte Mislabe	enance eled	Unclear	Part Lost/Mi Part Moved Positioned V	Vrong	Wrong Stock Pulled
	Inspectio Ripples in	n Bend			Cut Too Short Drill Holes		Offset	· —			Surge	Other
	Torque Waves in Extrusion Turning Sequence				Drawing Finish	<u> </u>	-}	Calibration Sequence				

Outside Dimensions

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Wave/Twist in Tube